

Date: Friday, 21/11/2008 8:09:25 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY CASE TRAY
Job Number	: 43079	Part Number	: D32611
Estimate Number	: 11392	Drawing Number	: D3261 REV A2
P.O. Number	:	Project Number	: N/A
This Issue	: 21/11/2008 S.O. No. :	Drawing Revision	: A2
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : MACHINED PARTS	Due Date	: 28/11/2008 Qty: 10 Um: Each
Previous Run	: 43079		
Written By	: <i>[Signature]</i> 08.11.21		
Checked & Approved By	:		
Comment	: Est B 04.12.02 Material no longer cut in-house KJ/JLM Est Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB750	UHMW .750 sheet
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24 MAT NOT PULLED



Comment: Qty.: 1.9950 sf(s)/Unit Total: 19.9500 sf(s)

UHMW .750 sheet

BATCH: 109986 IB 8-11-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3261

Dwg Rev: A2

Prog Rev: A2

IB 8-11-21



2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA421 Rev: A2 & Dwg D3261 Rev: A

2-Deburr per dwg D3261

Y.A

08/10/24

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE IB 8-11-21

Y.A

08/10/24

(12)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY CASE TRAY

Job Number: 43079

Part Number: D32611

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MF 08/11/24

(12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST137

MF 08/11/25 (12)

7.0

QC21

FINAL INSPECTION W/O RELEASE



08/11/26 MF

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-11-25

DART AEROSPACE LTD		Work Order: <u>43079</u>
Description: Battery Case Tray (Dual Battery Rack)		Part Number: D3261-1
Inspection Dwg: D3261	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

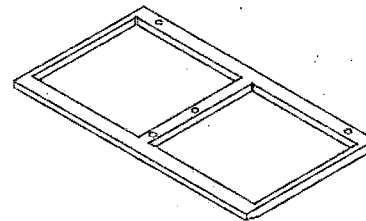
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	*B			
18.00	+/-0.005	18.00	✓			
12.25	+/-0.030	12.25	*B			
9.75	+/-0.030	9.750	✓			
1.27	+/-0.030	1.268	✓			
11.00	+/-0.030	11.006	✓			
Ø0.191	+0.005/-0.000	Ø0.196	✓			
0.50	+/-0.010	0.505	✓			
0.49	+/-0.03	0.498	✓			
2.00	+/-0.010	2.003	✓			
10.00	+/-0.010	9.996	✓			
1.00	+/-0.010	1.003	✓			
2.13	+/-0.010	2.123	✓			
Ø0.386	+0.005/-0.000	Ø0.388	✓			
4.00	+/-0.005	4.002	✓			
0.75	+/-0.030	0.762	✓			
0.125	-0.010/+0.030	0.140	✓			
0.55	+/-0.030	0.546	✓			
0.50	+0.000/-0.030	0.495	✓			
0.67	+0.000/-0.030	0.666	✓			

Measured by: <u>MA 8-11-24</u>	Audited by: <u>[Signature]</u>	Prototype Approval: N/A
Date: <u>08/11/24</u>	Date: <u>08/11/24</u>	Date: N/A

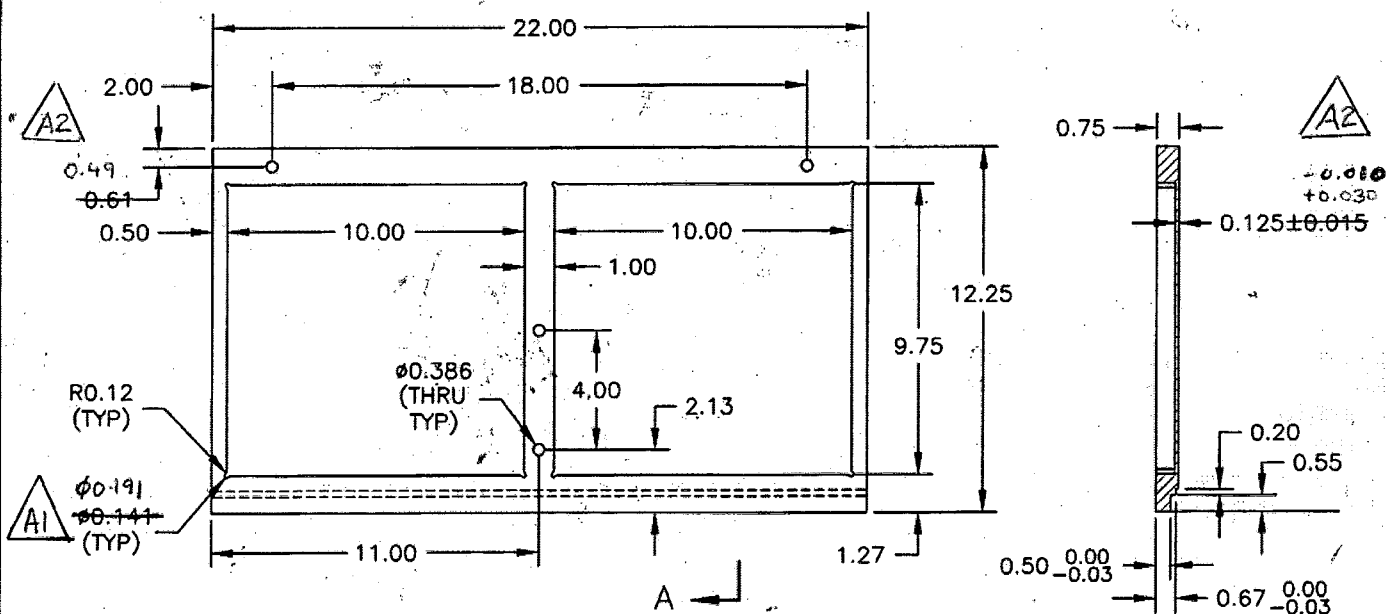
Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3261	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE BATTERY CASE TRAY	SCALE 1:6
A	04.04.06	NEW ISSUE	
A1	04.05.14	Ø0.191 WAS Ø0.141	
A2	04.06.08	0.125 ^{+0.010} / _{-0.030} WAS 0.125 ^{+0.010} / _{-0.015} ; 0.49 WAS 0.61	

RELEASED
04.04.27

A

**UNDER REVIEW****D3261-1****SECTION A-A**

THICKNESS CHANGE. Ø0.141 Ø0.191
04.04.25
04.10.29

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 43079

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